

over the guide pin mounted in the frame of the jig. Fig. 66 shows a cam for operating a sliding V, the method being evident from the illustration. Another form of quick-acting clamp is shown in Fig. 67. This device consists of a bar that is hinged on a stud at one end and has a slot cut in the opposite end to slip under a second stud. The screw that clamps the work also serves to secure the clamp in place.

A simple form of gang milling fixture is shown in Fig. 68, where the different pieces are clamped by separate screws held in a bar that can be swung out of the way to enable the work to be

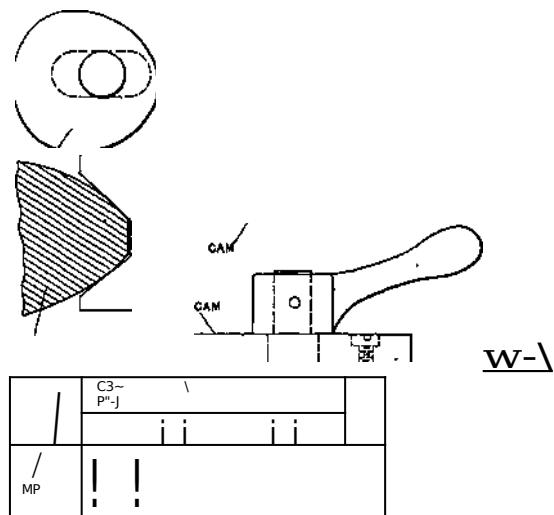


Fig. 66. Another Application of a Cam Clamping Device

removed from the jig. This also makes it possible to brush the chips out at the side of the jig.

In Fig. 69 is shown a clamping device that has been found useful on large work. It consists of four arms *A* with the ends bent to a right angle

and knurled so as to hold the work firmly in place. These arms are pivoted on the stud *B* and their action is guided by the blocks *C*. The spring handle *E* is pinned to the shank of the stud, and the upper edge of the handle is beveled to fit the rack *Z*, which is fastened to the side of the base. By turning the handle in the direction indi-